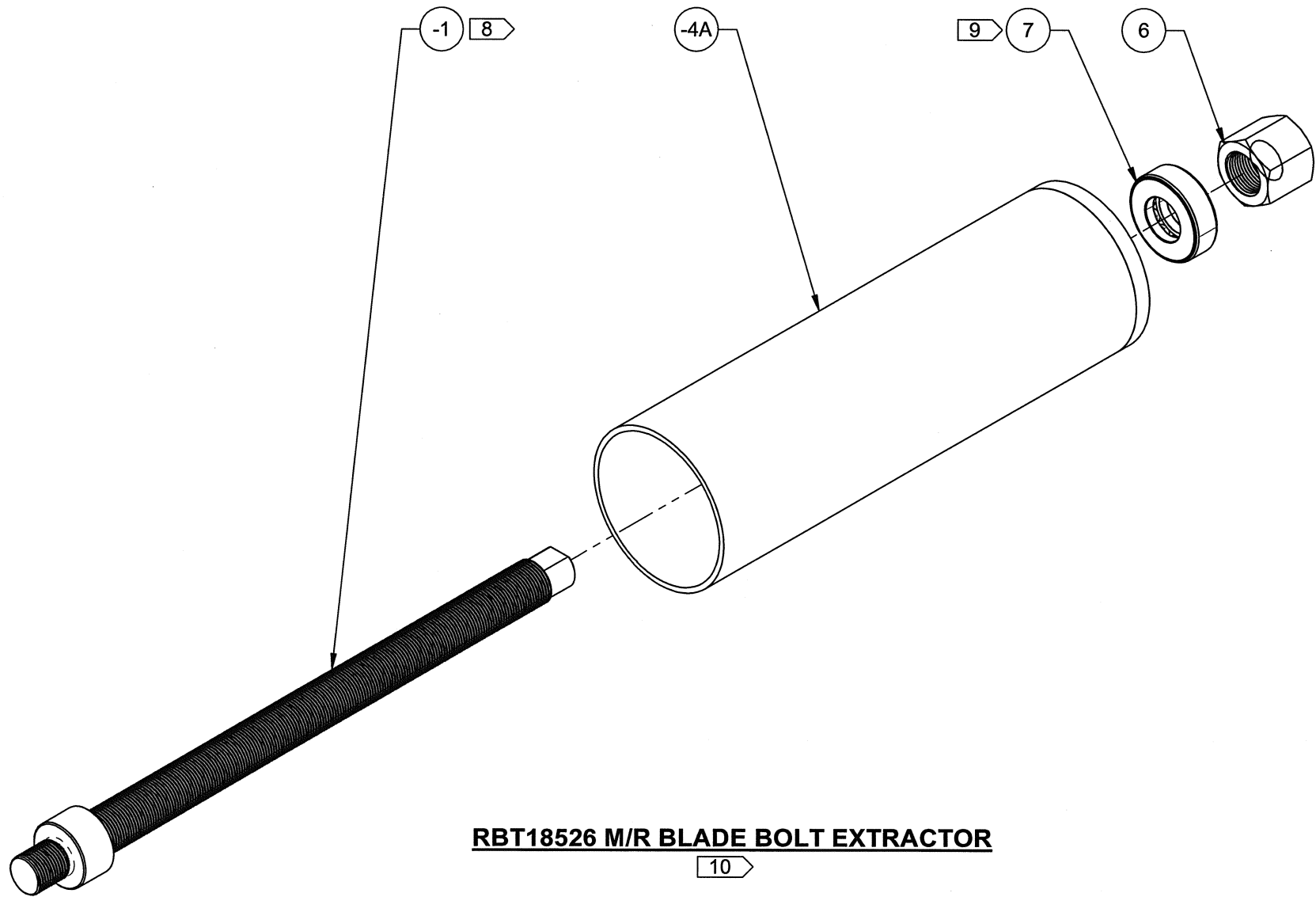
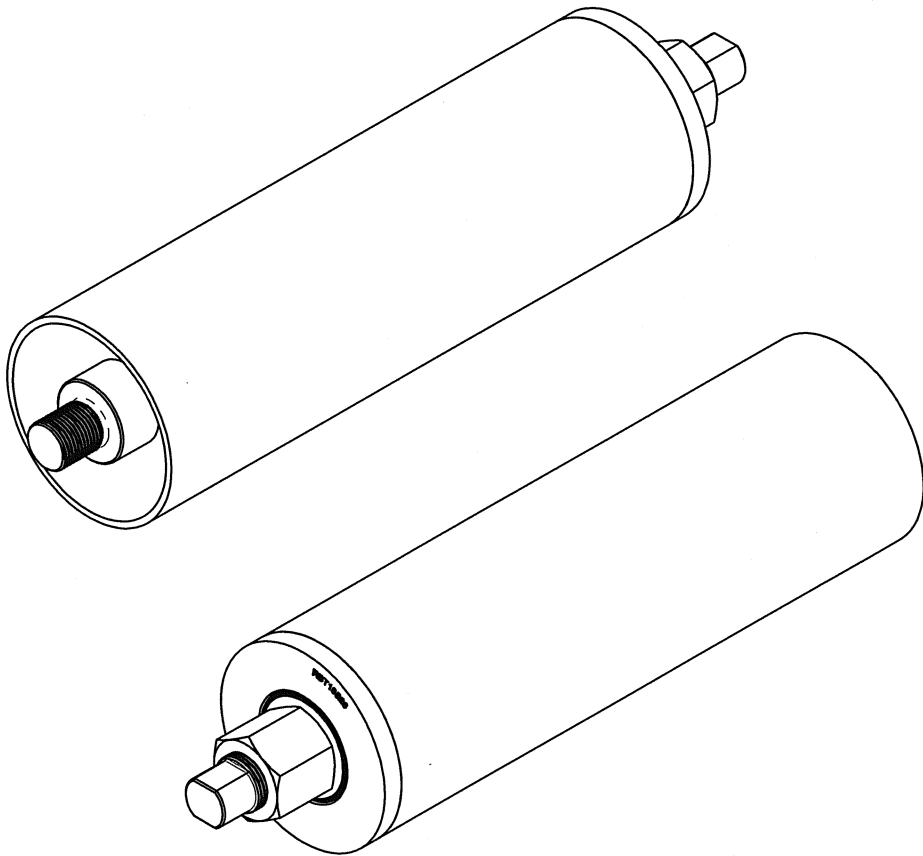


ITEM #	QTY	PART #	PART TITLE
-1	1	RBT18526-1	THREADED PULLER ROD
-4A	1	RBT18526-4A	TUBE WELDMENT
6	1	McMaster#90565A350 OR EQUIV	STEEL GRADE 8 HIGH HEX NUT 1"-14 X 1-5/16 HEIGHT
7	1	GRAINGER #4ZZR3 OR EQUIV	STEEL BANDED BALL THRUST BEARING 1.000" I.D X 1.969" OD X 0.625 THK

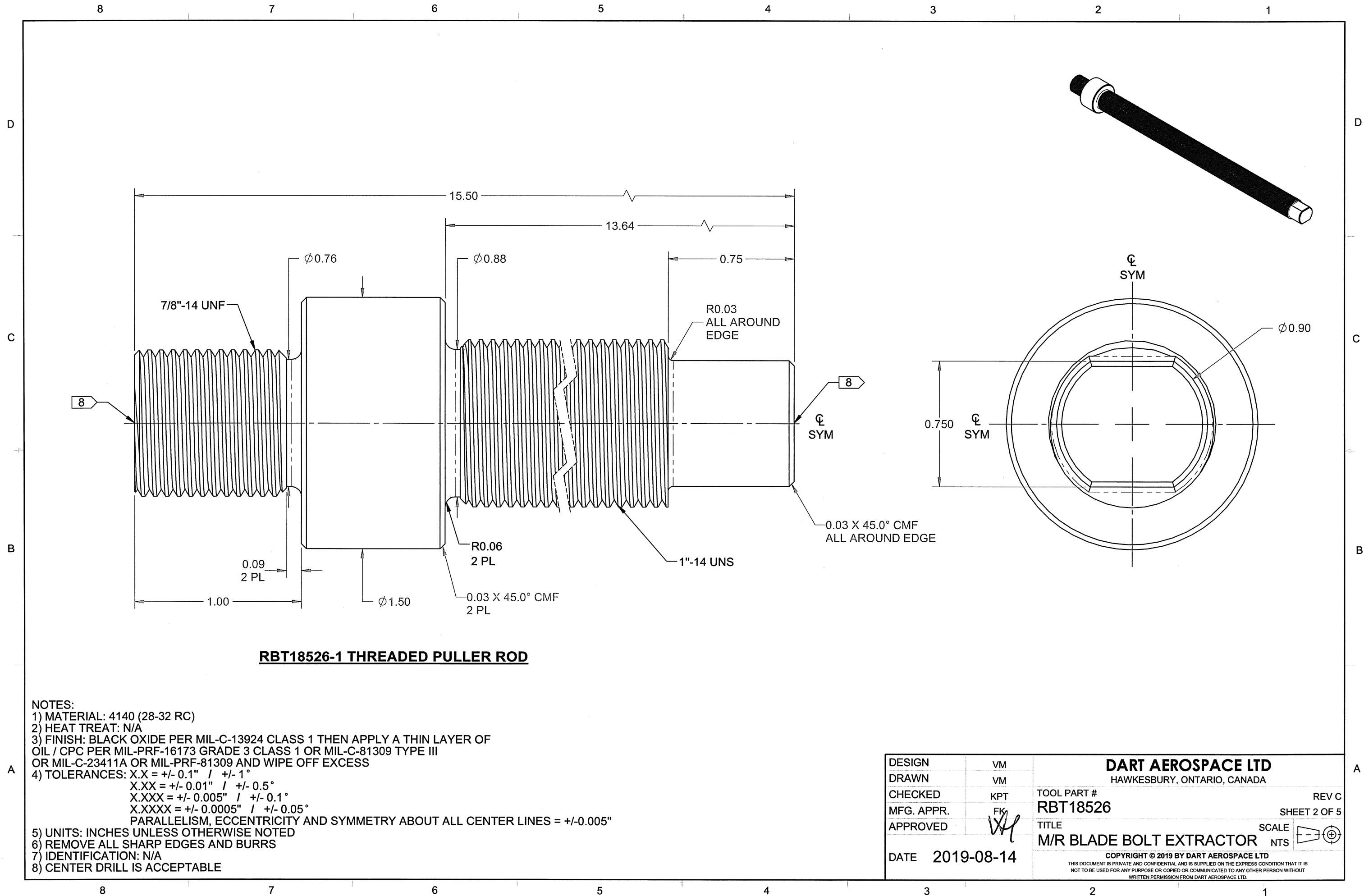


**RBT18526 M/R BLADE BOLT EXTRACTOR**

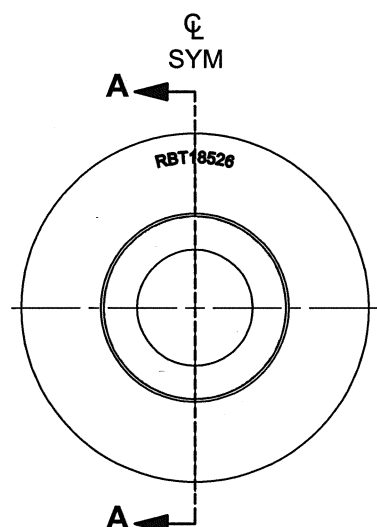
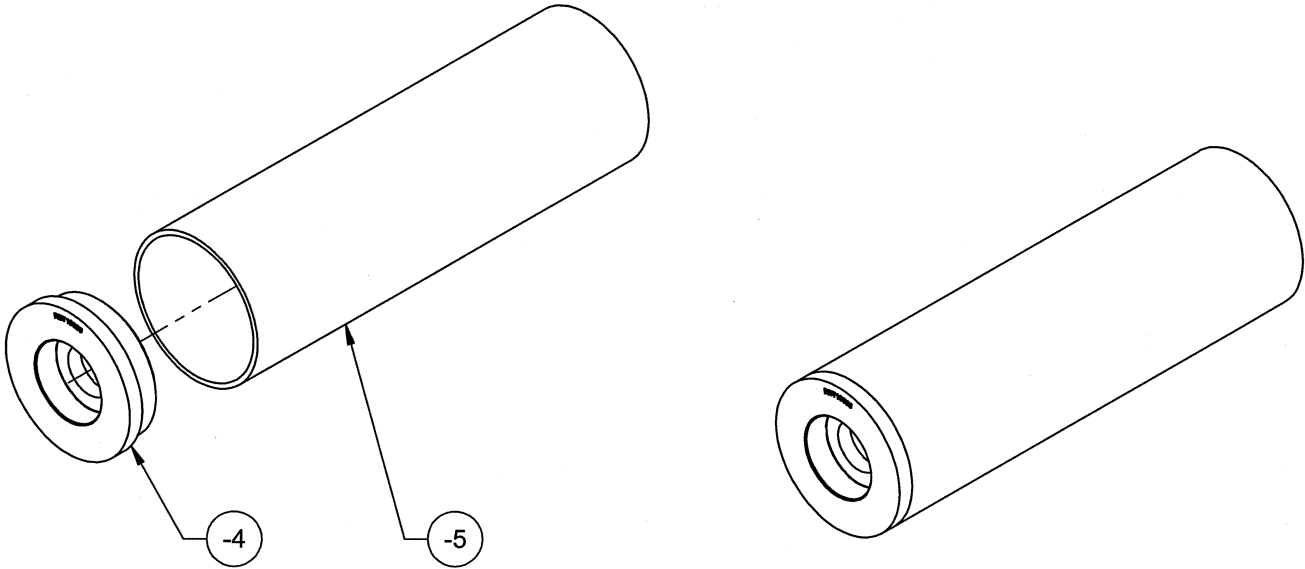
- NOTES:  
1) MATERIAL: N/A  
2) HEAT TREAT: N/A  
3) FINISH: N/A  
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"  
5) UNITS: INCHES UNLESS OTHERWISE NOTED  
6) IDENTIFICATION: N/A  
7) ASSEMBLE AS SHOWN  
8) APPLY GREASE MIL-PRF-23827 TYPE II ON THREADS OF ITEM -1  
9) PRESS FIT ITEM 7 WITH ITEM -4A  
10) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG



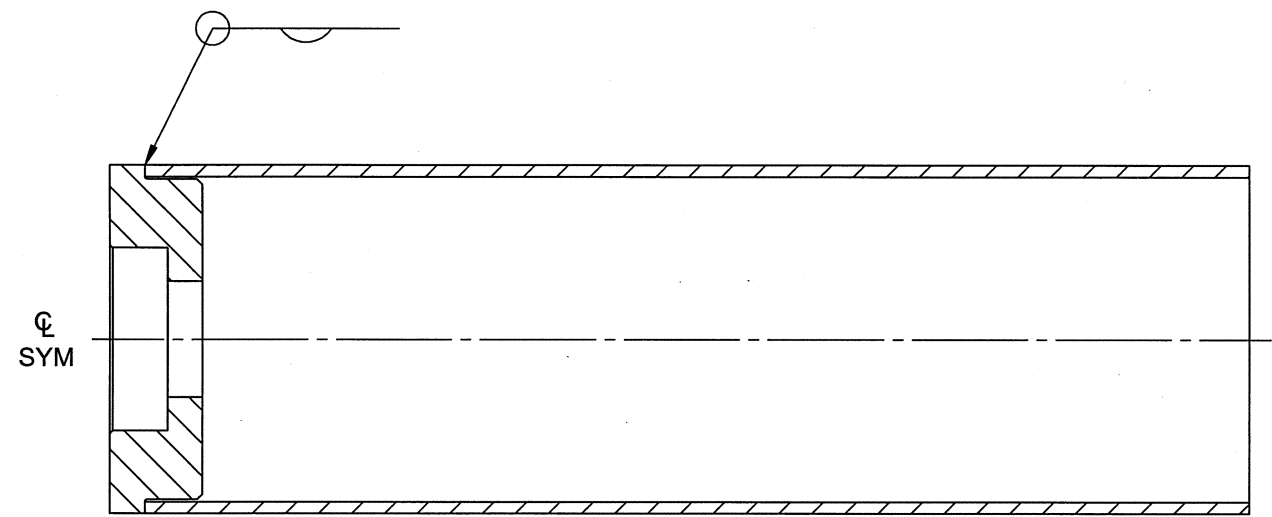
FOR OLDER REV's SEE PREVIOUS PDFs TEMPLATE UPDATED PER DART HBY STANDARD ITEM -1A ASSY DELETED ITEM -2 McMaster#95505A621 CHANGED FOR ITEM 6 McMaster#90565A350 ITEM -1 WAS MADE OUT OF 2 PARTS NOW IS MANUFACTURE IN A SINGLE PART, MATERIAL McMaster#92580A153 CHANGED FOR 4140 (28-32 RC), NOTE FOR UNDERCUT REPLACED BY DIMENSIONS 0.09 2PL X Ø 0.76 X R0.06 2 PL, UNDERCUT ADDED 0.09 2 PL X Ø 0.88 X R0.06 2PL, DIMENSION Ø 1.50 ADDED, DIMENSION 13.64 ADDED, DIMENSION 14.0 CHANGED FOR 15.50, DIMENSION 2X R.03 CHANGED FOR R0.03 ALL AROUND EDGE, DIMENSION .75 CHANGED FOR 0.750, DIMENSION 2X .03 X 45° CHANGED FOR 0.03 X 45.0° CMF ALL AROUND EDGE ITEM -4A FINISH BLACK OXIDE CHANGED FOR ZINC YELLOW PLATE ITEM -4 MATERIAL 1018/1020 CR CHANGED FOR 4140 (28-32 RC), DIMENSION Ø 1.9530/1.9520 ▽ .31 CHANGED FOR Ø 1.9689/1.9681 ▽ 0.625 +0.005/-0, ENGRAVING ADDED, DIMENSION 0.06 X 45.0° CMF ADDED, DIMENSION Ø 3.50 CHANGED FOR Ø 3.45, DIMENSION R0.008" MAX ADDED, DIMENSION R0.03 ADDED, DIMENSION 0.03 X 45.0° CMF ADDED, DIMENSION .63 CHANGED FOR 1.00, DIMENSION .38 REPLACED BY DIMENSION 0.62 ITEM -5 MATERIAL DOM CHANGED FOR A513 TYPE 5 DOM TUBING, DIMENSION 11.2 CHANGED FOR 11.87, ENGRAVING REMOVED		19-820	VM
REV.	DESCRIPTION	ECN #	BY
DESIGN	VM	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	KPT	TOOL PART #	REV C
MFG. APPR.	FK	<b>RBT18526</b>	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DATE 2019-08-14		<b>M/R BLADE BOLT EXTRACTOR</b>	NTS
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ITEM #	QTY	PART #	PART TITLE
-4	1	RBT18526-4	BEARING PLATE
-5	1	RBT18526-5	TUBE



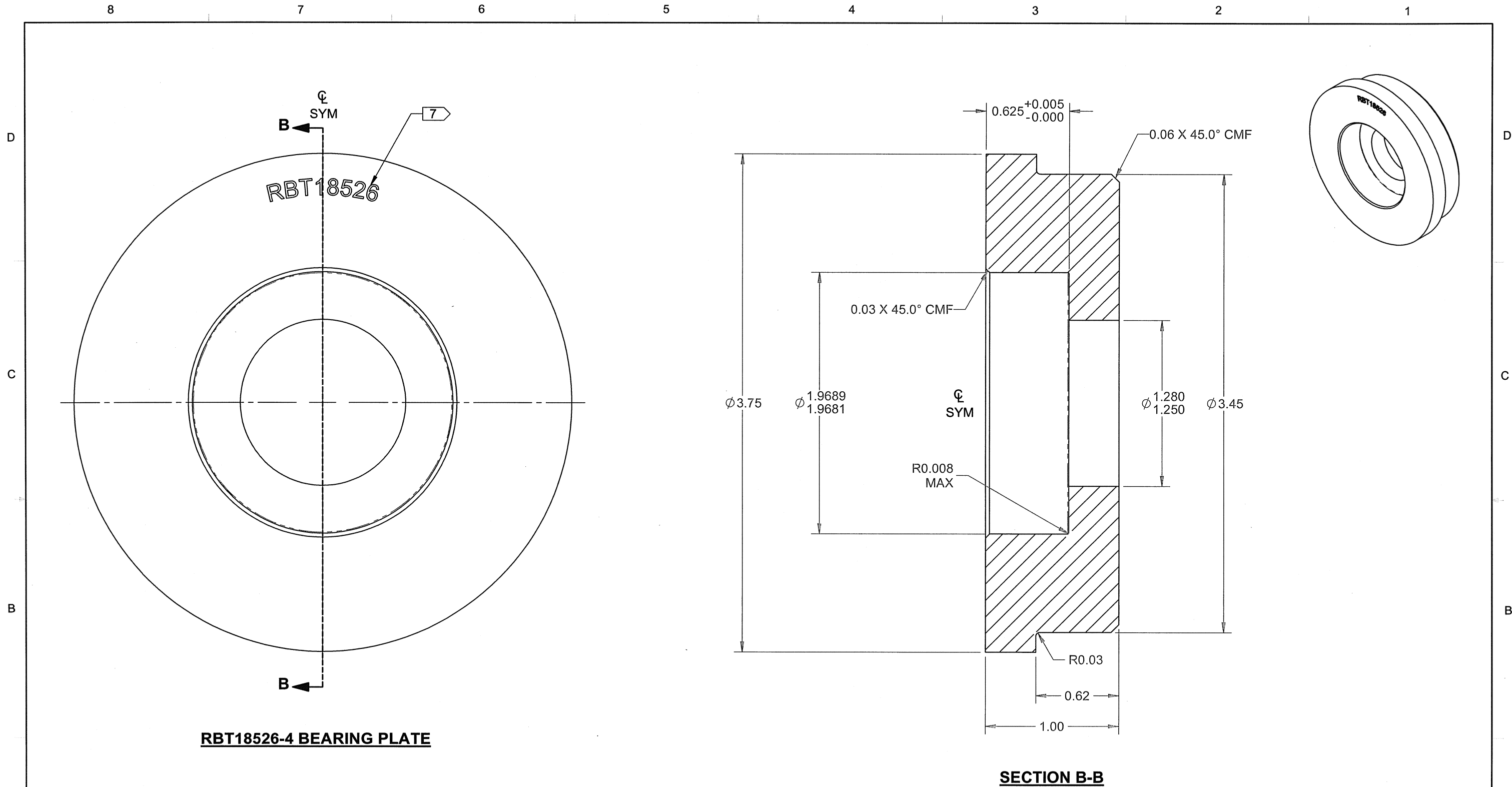
**RBT18526-4A TUBE WELDMENT**



**SECTION A-A**

NOTES:  
1) MATERIAL: N/A  
2) HEAT TREAT: N/A  
3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2  
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
                  X.XX = +/- 0.01" / +/- 0.5°  
                  X.XXX = +/- 0.005" / +/- 0.1°  
                  X.XXXX = +/- 0.0005" / +/- 0.05°  
                  PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"  
5) UNITS: INCHES UNLESS OTHERWISE NOTED  
6) IDENTIFICATION: N/A  
7) ASSEMBLE AS SHOWN  
8) REMOVE ALL WELD SPATTERS

DESIGN	VM	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	TOOL PART # <b>RBT18526</b>	REV C SHEET 3 OF 5
DRAWN	VM			
CHECKED	KPT			
MFG. APPR.	FK			
APPROVED	<i>WJ</i>			
DATE 2019-08-14		TITLE <b>M/R BLADE BOLT EXTRACTOR</b>		
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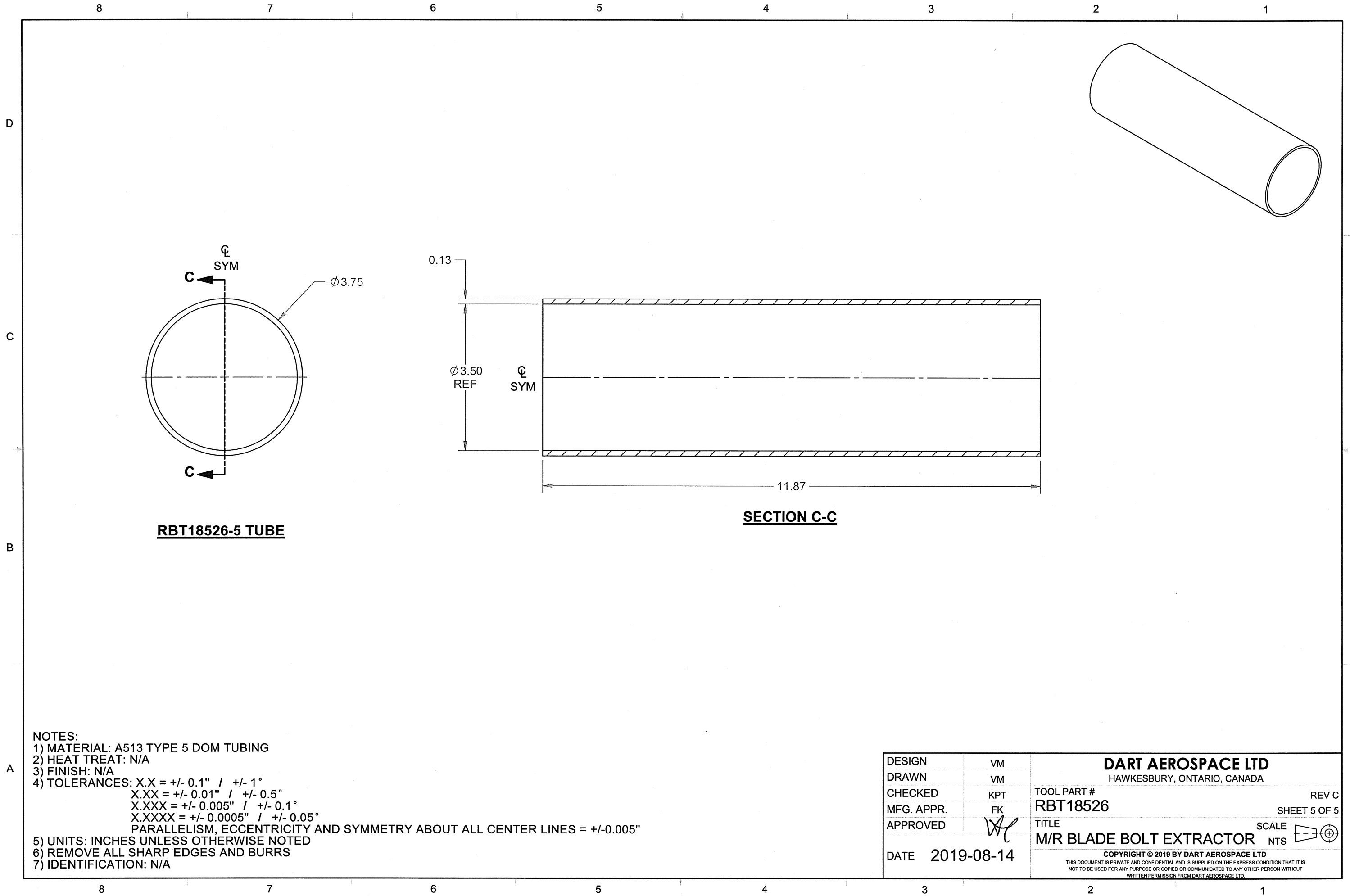


**RBT18526-4 BEARING PLATE**

**SECTION B-B**

NOTES:  
1) MATERIAL: 4140 (28-32 RC)  
2) HEAT TREAT: N/A  
3) FINISH: N/A  
4) TOLERANCES: X.X =  $\pm 0.1$ " /  $\pm 1^\circ$   
X.XX =  $\pm 0.01$ " /  $\pm 0.5^\circ$   
X.XXX =  $\pm 0.005$ " /  $\pm 0.1^\circ$   
X.XXXX =  $\pm 0.0005$ " /  $\pm 0.05^\circ$   
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES =  $\pm 0.005$ "  
5) UNITS: INCHES UNLESS OTHERWISE NOTED  
6) REMOVE ALL SHARP EDGES AND BURRS  
7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N, "RBT18526", AS SHOWN

DESIGN	VM	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	KPT	TOOL PART #	REV. C
MFG. APPR.	FK	<b>RBT18526</b>	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DATE	2019-08-14	<b>M/R BLADE BOLT EXTRACTOR</b>	NTS
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NOTES:  
1) MATERIAL: A513 TYPE 5 DOM TUBING  
2) HEAT TREAT: N/A  
3) FINISH: N/A  
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"  
5) UNITS: INCHES UNLESS OTHERWISE NOTED  
6) REMOVE ALL SHARP EDGES AND BURRS  
7) IDENTIFICATION: N/A

DESIGN	VM	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	KPT	TOOL PART #	REV C
MFG. APPR.	FK	<b>RBT18526</b>	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DATE	2019-08-14	<b>M/R BLADE BOLT EXTRACTOR</b>	NTS
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